Work Order ID 65200

January 7, 2011 3:51:15 PM

Item ID: D3859-041 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Wearplate

Start Date: 1/10/11 **Start Qty:** 8.00 **Cust Item ID:**

Required Date: 1/24/11 **Req'd Qty:** 8.00 **Customer:**

Reference:

Approvals: **Process Plan:** MK **Date:** 10-11-07 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3859	**Revision Nbr** Rev A								Pro →
100 Waterjet FLOW CNC Waterjet 304.063	FLOW WATER JET **Memo** 1-Cut as per Dwg D3859 ☐Dwg Rev: A ☐Prog Rev: A ☐2-Deburr if necessary	0.00 0.00				RB 11-1-10 (8)			
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				RB 11-1-10			
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 S 11/01/10				(x8)			

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	Perm. Change PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/10	# 100	ADD correct information to WARN Bug					S 11/01/10

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes No **DQA:** ______ **Date:** ________

Resolution: ________ **Disposition:** ________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 65200

January 7, 2011 3:51:16 PM

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Run Start

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Large Fab Large Fab	Large Fab	0.00				EL	11-1-18		x8
	Memo 1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod Batch: M114509 2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: M116468 *****use DT9462 for welding*****	0.00							
140 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00	CPC 11.01.19						
	Memo	0.00							
150 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00	S 11.01.19			x4			
	Memo	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 65200

January 7, 2011 3:51:16 PM

Item ID: D3859-041 **Accept**

Setup **Start** / **Stop**

Revision ID:

Item Name: Wearplate

Start Date: 1/10/11 **Start Qty:** 8.00

Required Date: 1/24/11 **Req'd Qty:** 8.00

Cust Item ID:

Customer:

Reference:

Run **Start** / **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 9:10 ☐OVEN TEMPERATURE: 320° ☐FINISH TIME: 9:40.	0.00 0.00				8	BR	11-01-19	
170 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=7 MM	11/6/19		8	∅		
180 Packaging Packaging	Identify as per dwg & Stock Location: 56U Memo	0.00 0.00			—	11/1	/2019	(8D)	VP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65200

January 7, 2011 3:51:17 PM

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Revision ID:

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Item Name: Wearplate

Start Date: 1/10/11 **Start Qty:** 8.00 **Cust Item ID:**

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Run **Start**

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

Stop

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00						11/01/20	[signature]
QC	**Memo**	0.00							
Quality Control									

JMF

11-01-20

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 7, 2011 3:51:15 PM

Work Order ID: 65200

Parent Item: D3859-041

Parent Item Name: Wearplate

Start Date: 1/10/11 **Required Date:** 1/24/11

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	34.8100	0.85	6.8	R	11-1-10	
D3009-3 Cup		Manufactured	No			130	Each	117.0000	6	48	EC	11-1-18	

M304S16GA locations:

Location		Loc Qty	Loc Code	
MAT		34.81		
	111323	0		
	115953	34.81		115953

(8)

D3009-3 locations:

Location		Loc Qty	Loc Code	
WA		117		
	42377	117		48

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	65200
Description: Wearplate	Part Number:	D3859-1
Inspection Dwg: D3859 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.879	+0.010/-0.001	.881	✓		V R02	
0.75	+/-0.030	.750	✓		V	
4.250	+/-0.010	4.247	✓		V	
3.00	+/-0.030	2.998	✓		V	
5.75	+/-0.030	5.744	✓		V	
9.000	+/-0.010	9.000	✓		T R01	
1.50	+/-0.030	1.50	✓		V	
20.40	+/-0.030	20.40	✓		T	
0.063	+/-0.010	.057	✓		V	

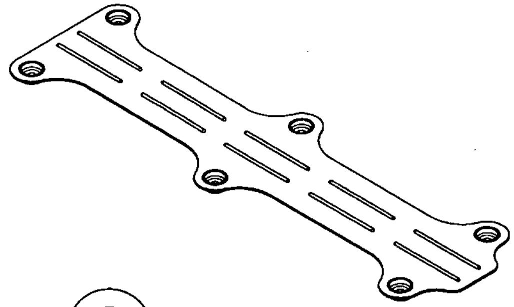
Measured by:	R
Date:	11-1-10

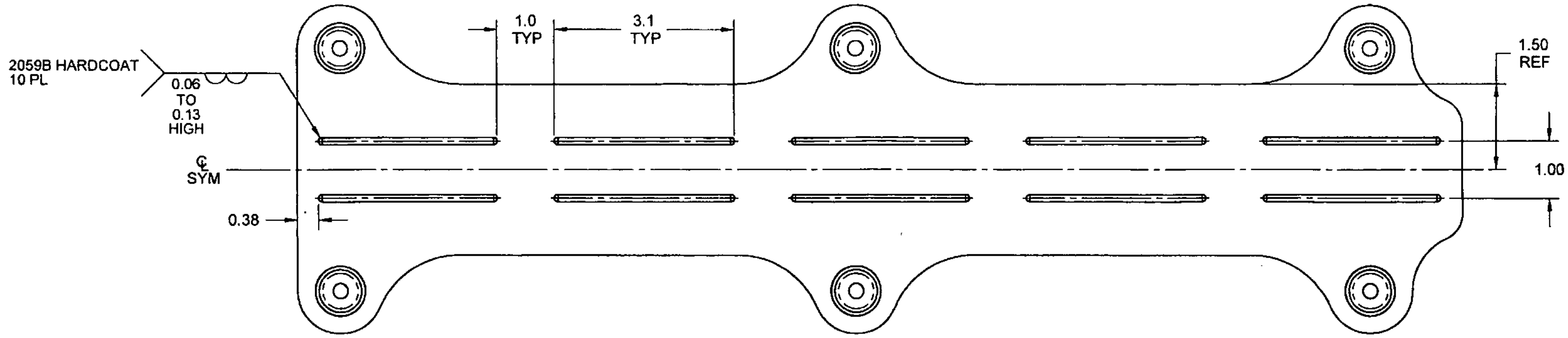
Audited by:	[signature]
Date:	11/01/10

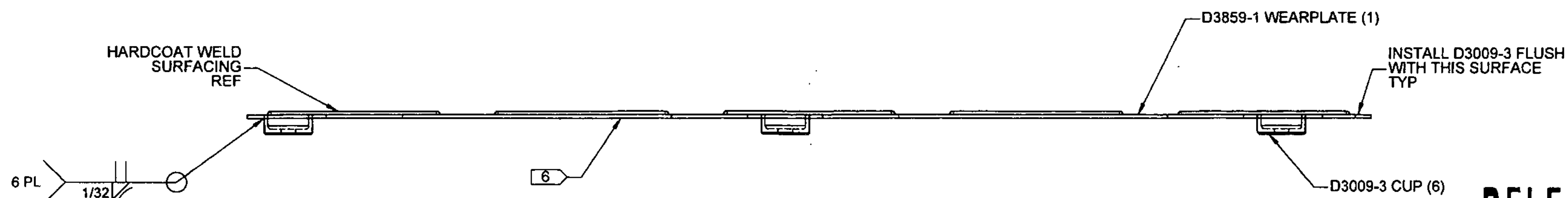
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change		Revised by	Approved
A	09.05.20	New Issue	P/O D3859-041	KJ	[signature]

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP







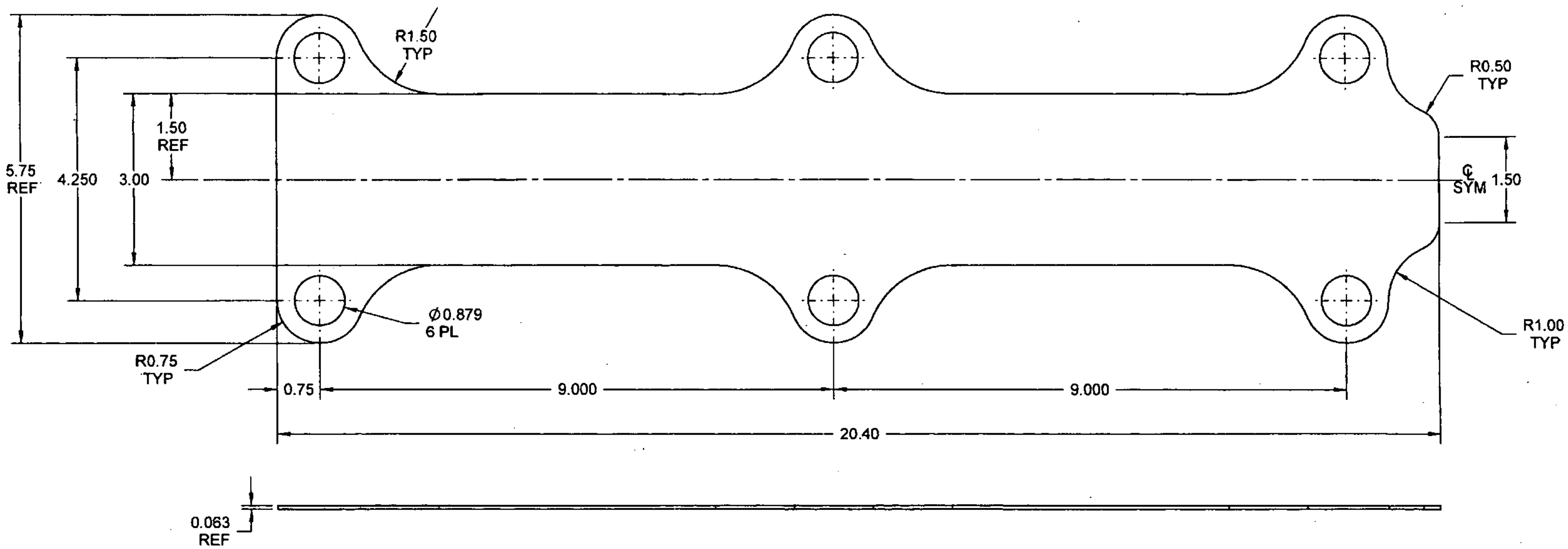
D3859-041 WEARPLATE

RELEASED 09 01.26

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & S/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.46 lbs
8) WELD PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.01.26

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3859 — REV. A — SHEET 1 OF 2
MFG. APPR.		
APPROVED		TITLE WEARPLATE — SCALE NTS
DE APPR.		
DATE	09.01.26	



D3859-1 WEARPLATE

RELEASED 09.01.26

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.29 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3859 — REV. A — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE WEARPLATE — SCALE NTS
DE APPR.		
DATE	09.01.26	